

Work Order ID 56776

March 10, 2010 7:16:18 AM



Page 1

Item ID: D3815-1

Revision ID:

Item Name: Angle

Start Date: 3/10/10

Start Qty: 12.00

Required Date: 3/12/10

Req'd Qty: 12.00

Reference:

Accept

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3815

Rev A

100

0.00



Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

0.00

1-Cut as per Dwg D3815 ☐ Dwg Rev: A ☐ Prog Rev: A

☐

****grain direction along 4.30" **** ☐ 2-Deburr if necessary

1810-3-10

2024.063

15

110

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

1810-3-10

120

0.00



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

8106314

15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56776

March 10, 2010 7:16:18 AM

Page 2

Item ID: D3815-1

Accept

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

1- deburr if necessary
D3815

0.00

0.00

2- Bend as per Dwg

SA 10/03/12

15 0

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/6/12

15

-1

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

PR 10-3-15

15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56776

March 10, 2010 7:16:19 AM



Page 3

Item ID: D3815-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle

Start Date: 3/10/10

Start Qty: 12.00



Cust Item ID:

Required Date: 3/12/10

Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

EP 10/03/16 (15)

170

Identify as per dwg & Stock Location: G-A

0.00



Packaging

Memo

0.00

Packaging

EP 10/03/16 (15)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/16 J

PL 10-3-14
(15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 10, 2010 7:16:17 AM

Page 1

Work Order ID: 56776

Parent Item: D3815-1

Parent Item Name: Angle

Comments: IPP Rev:A 08-09-18 new issue DD verified by:EC

Start Date: 3/10/10

Required Date: 3/12/10

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	133.8802	5.8459	7.4		



2024-T3 .063 sheet



B 10-3-10

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	133.8801505	
105916	1.09	
110980	5.4854	
111787	0.00475051	
113866	69.3	
113867	56	
19059	2	

113867

⑤

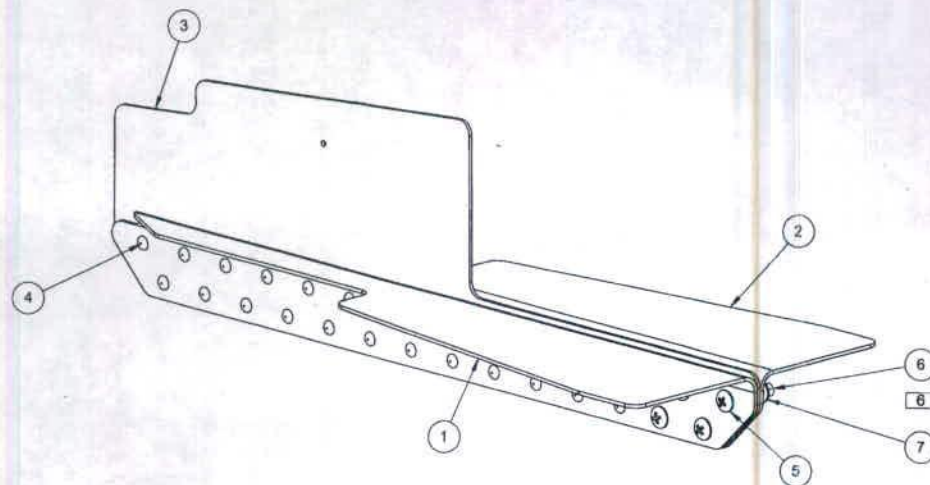
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -041
1	D3815-1	ANGLE	1
2	D3815-2	ANGLE	1
3	D3815-3	WEB	1
4	MS20470AD4-6	RIVET	25
5	AN526C832R14	SCREW	4
6	MS21042L08	NUT	4
7	NAS1149DN832J	WASHER	4

D3815-041 WEB ASSEMBLY

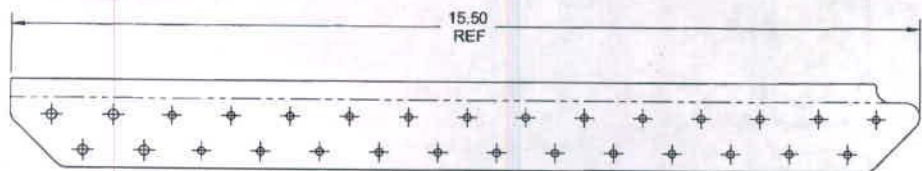
NOTES:

- 1) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N D3815-041 USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.88 lbs
- 6) INSTALL LOOSE (4 PLACES) AFTER POWDER COAT

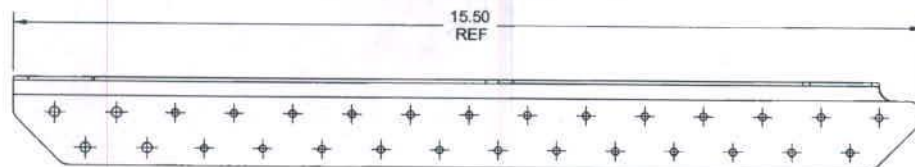
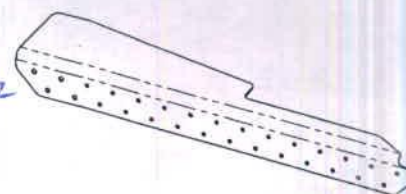
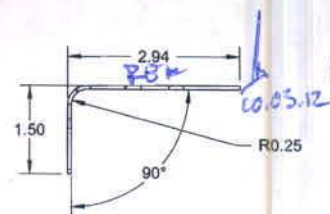
RELEASE
09/13/10

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE		08.09.22
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.22		

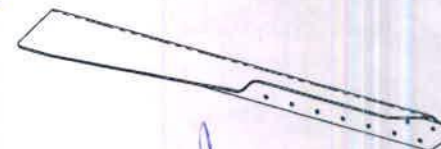
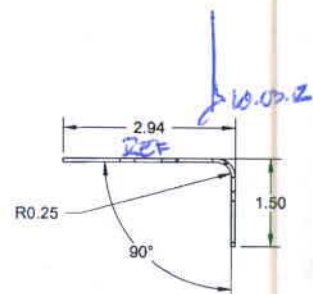
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3815	REV. A
TITLE WEB	SHEET 1 OF 5
SCALE NTS	
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D3815-1 ANGLE
(MADE FROM D3815-1F)

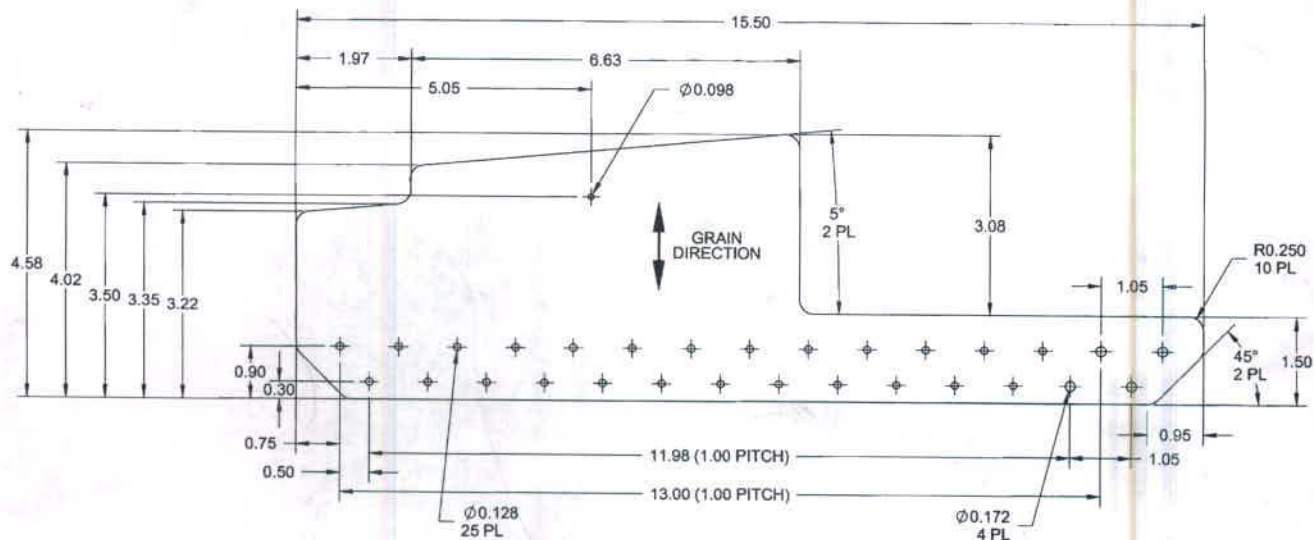


D3815-2 ANGLE
(MADE FROM D3815-1F)



RELEASED
09/01/13

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DE APPR.		WEB	NTS
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D3815-3 WEB

RELEASED
09/01/13 JH

- NOTES:**
- 1) MATERIAL: 2024-T3 X 0.063 ALUMINUM SHEET PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES 0.005 TO 0.010
 - 4) IDENTIFICATION: N/A
 - 5) WEIGHT: 0.28 lbs

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